

Work Order ID 83917

83917

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April-27-12 11:20:17 AM

Item ID: D2562-001 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 27/04/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2562 | Rev D | | | | | | | | |
| 100 | NC BRAKE | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Brake NC | Memo <u>cut at 20.73</u> | 0.00 | | | | <u>8</u> | | <u>SAD</u> | <u>12-11-05</u> |
| Brake NC | Punch to length as per Dwg D2562 | | | | | | | | |
| 110 | Small Fab | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | <u>8</u> | | <u>SAD</u> | <u>12-11-05</u> |
| Small Fab | 1- Bend end as per Dwg D2562 Angle "D"2-Deburr | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | <u>8</u> | | | |
| Quality Control | | | | | | | | | |

DAS
15
2-8
1208

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | START TIME: 8-15 | | | | | | | | |
| | FINISH TIME: 4000 F | | | | | | | | |
| | OVEN TEMPERATURE: 8-45 | | | | | | | | |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location: <u>ST 212</u> | 0.00 | | | | | | | |
| | Memo | 0.00 | | | | | | | |

W122878

8x0

MT
12/11/06

8x

12/11/06

8

12/11/07 JB

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MCS 12-11-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

April-27-12 11:20:21 AM

Page 1

Work Order ID: 83917

83917

Parent Item: D2562-001

D2562-001

Parent Item Name: Strut

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.500W.035 | | Purchased | No | | | 100 | f | 172.5474 | 1.7067 | 14.37221 | | | |

M304TR0 500W 035

304 RD Tube .500 x .035W

**

SAN 12-11-05

Location

Loc Qty

Loc Code

MAT017

172.5473823

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

119644

2.1209

120633

155.42121

21123449

14.3723

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

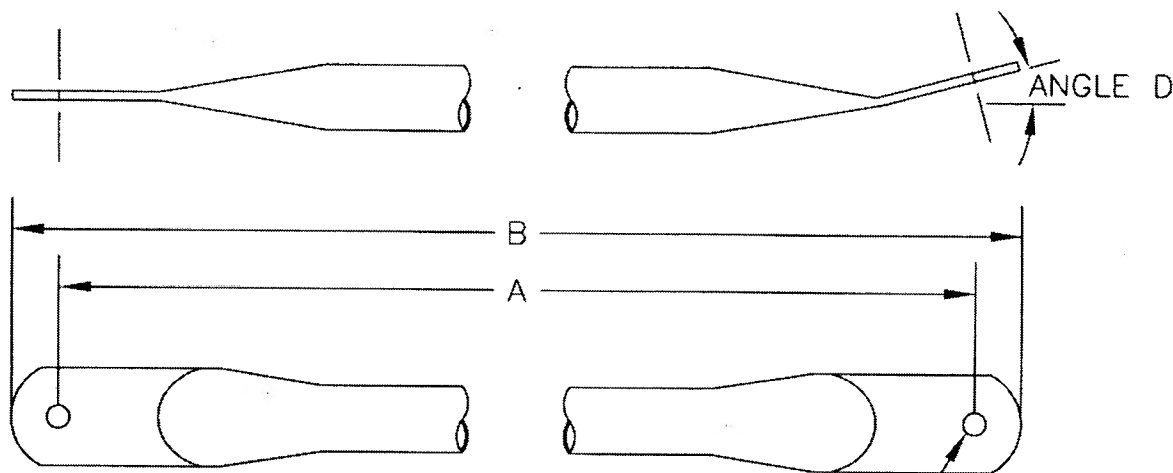
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART

| DESIGN | CP | DRAWN BY | RF | DART AEROSPACE LTD |
|---------|--------------------|----------------------------------|--------------------|-----------------------------|
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.05.18 | DRAWING NO. | D2562 | REV. D |
| | | TITLE | STRUT | SHEET 1 OF 1 |
| A | | NEW ISSUE | | SCALE |
| B | 98.10.15 | UPDATED MATERIAL NOTE (TSR A603) | | 1:2 |
| C | 02.06.05 | ADD -005; ADD FINISH | | |
| D | 05.05.18 | ADD -007/-011/-013; UPDATE -005 | | |



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

| PART # | DIM A | DIM B | DIA C | ANG D |
|-----------|-------|-------|-------|-------|
| D2562-001 | 19.68 | 20.48 | - | 10 |
| D2562-003 | 20.37 | 21.17 | - | 18 |
| D2562-005 | 29.00 | 29.80 | - | 30 |
| D2562-007 | 19.22 | 20.02 | - | 0 |
| D2562-011 | 25.79 | 26.59 | - | 16 |
| D2562-013 | 26.63 | 27.43 | - | 24 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83917 MLC*
12/04/27

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27